

IN THE CLAIMS:

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Claims 1-13 (Cancel)

14. (Represented - formerly independent claim 1) A method for producing a large-volume, cup-shaped or tub-shaped container of thermoplastic material, the method comprising:

extruding a hose-shaped pre-form of compact plastic material to a predetermined length,

initially widening the extruded pre-form by a predetermined amount,

subsequently moving a core from below into the widened pre-form,

subsequently clamping the widened pre-form at a lower free end thereof sealingly against the core, such that an opening of the container is formed, wherein an area of the opening approximately is equal to a cross-sectional area of the container, and

subsequently shaping the pre-form by means of shaping air into the container.

15. (Represented - formerly dependent claim 2) The method according to claim 14, wherein the core is configured as a shaping body, further comprising forming the container by means of a vacuum on the core.

16. (Represented - formerly dependent claim 3) The method according to claim 14, wherein the core is configured as a shaping body, further comprising forming the container by means of a vacuum or blowing air on a two-part hollow mold surrounding the core at a spacing.

17. (Represented - formerly dependent claim 4) The method according to claim 14, further comprising widening the extruded pre-form by at least two rod-shaped spreading elements.

B 18. (Represented - formerly dependent claim 5) The method according to claim 14, further comprising widening the extruded pre-form by the core.


19. (Represented - formerly dependent claim 6) A device for producing a large-volume, cup-shaped or tub-shaped container of thermoplastic material, the device comprising

an extrusion head for forming a hose-shaped pre-form of a single-layer compact plastic material,

a spreading unit mounted below the pre-form and movable from below into the pre-form by a relative movement, and a core movable from below into the pre-form after the pre-form has been widened by the spreading unit, wherein the core comprises at least one two-part clamping element, wherein

the core can be loaded with a vacuum, and wherein the core is configured to form an opening of the container, wherein an area of the opening is approximately equal to a cross-sectional area of the container.

20. (Represented - formerly dependent claim 8) The device according to claim 19, wherein the spreading unit comprises at least two spreading elements that can be moved apart.

 21. (Represented - formerly dependent claim 9) The device according to claim 20, wherein the spreading elements have different cross-sectional shapes.

22. (Represented - formerly dependent claim 10) The device according to claim 20, wherein the spreading elements are formed of parts of the shaping body.


23. (Represented - formerly dependent claim 11) The device according to claim 20, wherein the spreading elements are configured to be radially movable.

24. (Represented - formerly dependent claim 12) The device according to claim 20, wherein the spreading elements are configured to be pivotable.

25. (Represented - formerly dependent claim 13) The device according to claim 19, wherein the spreading unit is formed by a spreadable or foldable core.

26. (Represented - formerly independent claim 7) A device for producing a large-volume, cup-shaped or tub-shaped container of thermoplastic material, the device comprising

an extrusion head for forming a hose-shaped pre-form of a single-layer compact plastic material,

 a spreading unit mounted below the pre-form and movable from below into the pre-form by a relative movement, and a core movable from below into the pre-form after the pre-form has been widened by the spreading unit, wherein the core comprises at least one two-part clamping element and a hollow mold loadable with vacuum or blowing air and surrounding the core at a spacing, wherein

the core is configured to form an opening of the container, wherein an area of the opening is approximately equal to a cross-sectional area of the container.

27. (Represented - formerly dependent claim 8) The device according to claim 26, wherein the spreading unit comprises at least two spreading elements that can be moved apart.

28. (Represented - formerly dependent claim 9) The device

according to claim 27, wherein the spreading elements have different cross-sectional shapes.

29. (Represented - formerly dependent claim 10) The device according to claim 27, wherein the spreading elements are formed of parts of the shaping body.

30. (Represented - formerly dependent claim 11) The device according to claim 27, wherein the spreading elements are configured to be radially movable.

31. (Represented - formerly dependent claim 12) The device according to claim 27, wherein the spreading elements are configured to be pivotable.

32. (Represented - formerly dependent claim 13) The device according to claim 26, wherein the spreading unit is formed by a spreadable or foldable core.

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